Work Order May-29-12 2:56:42				*840	129*						Page 1
Revision ID:	209-669-043			Accept	*N900	040	100)* s	Setup Sta	. ! 🗸	S1*
Item Name: Rep	placement Skidtube								Sto	^p *N	S2*
Start Date: 29/	/05/2012 Start Q	ty: 1.00	*1*		Cust Item	ID:					
Required Date: 16/ Reference:	/07/2012 Req'd (2ty: 1.00	*1*		Customer:						
Approvals: Pi	rocess Plan:	ブ	Date: 12/05	29 Tooling:	D	ate:		F	Run Sta	I/I	R1*
Q	C:		_ Date:	SPC (Y/N):	D	ate:			Sto	^p *N	R2*
Sequence ID/ Work Center ID	Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			-							
D2906	Rev B										
*100 *100* DC Document Control	DOCUME	NT CONTRO Memo Photocopy		0.00 0.00 ne labels per PPP D205-669-0	90) 143 Chg 092 Pev W	d 12 590	ih		N	A OS	
110				0.00							
110 Skidtubes Skidtubes	Skidtubes	Memo - Inspect ma	ut'l D2500-1-190 for da	0.00 mage	,						-
		-Drill pilot !	noles using drill jig DT8)	149, DT8711-2 & DT8711-3	(Do not use	SAO	12.0	06-20			
		-Open noles	to 0.500" as per Dwg E	2906 without cutting fluid				Λ			
		-Deburr and	blow out all chips from		_/	/	\bigcap	7/	17	628	
	***	-Acid etch a	nd Alodine tube per OS	1 005 4.1		- (<i>'</i>	MOL	100	4000	

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Dail Ac	ospace	LIG							• •
W/O:			WC	ORK ORDER CHANG	ES				7.0.202
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	Re	esolution:	Dispositio	n: <u>'</u>	_ QA: N/C C	losed:		Date: _	
NCR:	CR:		WORK ORD	ER NON-CONFORMA	ORMANCE (NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC inspector
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Work Orde May-29-12 2:56		929		*849	29*	,				Page
Item ID: Revision ID:	D209-669-0	43		Accept	*N900	040	10	N *	Setup Star	*NS1*
Item Name:	Replacement S	Skidtube							Stop	*NS2*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1 *1		Cust Item I Customer:	D:				14(1)
Approvals:	Process Pla	nn:	Date:	Tooling:	D:	 ate:	-	1	Run Star	* *NR1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
120		QC3- Inspect Part Finish		0.00				_		•
120 QC Quality Control		Мето		0.00						(2.07-04
130				0.00				\circ		
130 Skidtubes		Skidtubes Memo		0.00				0	SAD	11-07-04
Skidtubes		· •	place per QSI 015	Allow 12 Hrs. cure time before	cutting					, · · · · · · · · · · · · · · · · · · ·

Page 2

Otty Part Number Description Batch
A/R Sikaflex-291

Sikaflex expire date: 13-64-12

Start Time: 9h0 Date: 12-07-04

Fin Time: 1:30 Date: 12-07-05

pick: PAI description Batch

Qty 1

P/N D2926-3 description Web

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W/O:	, , , , , , , , , , , , , , , , , , ,		V	VORK ORDER CHAN	GES				Approval
DATE	STEP		PROCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No.		PAR	#: Fault Ca	tegory:	NCR: Yes	No DQ	A :	_ Date: _	
\$4 	R	esolution:	Disposit	ion: '	QA: N/C C	losed:	<u> </u>	Date: _	<u> </u>
NCR:	6-17	•	WORK OR	DER NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of	NC		ction B	Verific	ation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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May-29-12 2:50	6:42 PM			O4:	1/9					· · · · · ·	Page	3
Item ID: Revision ID:	D209-669-04			Accept	*N900	040	100)*	Setup Star	iVi	S1*	
Item Name:	Replacement S	Skidtube							Stop	, *N	S2*	
Start Date:	29/05/2012	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	16/07/2012	Req'd Qty: 1.00	*1*		Customer:							
Reference:			•									
Approvals:	Process Pla	in:	Date:	Tooling:	Da	ate:		F	Run Star	"1/	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	` *N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
140		DENIDING MACHINE	CDOCCTUDEC	0.00								
140 CNC Bend 1		BENDING MACHINE	- CROSSTUBES									
CNC Bella 1 CNC Delta 100 Ben	dar	Memo	COD42EN	0.00		_	,			4172		
CIVE DENA 100 DEN	uci		s as per Dwg. D2906	D & COBRAFT on CNC Be	nder and Folio F1	De	12/07	1/05			#	
		2-Cut tuocs	as per Dwg. D2900		Z							
150	•			0.00								
150		Skidtubes										
Skidtubes		Memo		0.00								
Skidtubes		-Deburr end	ls and remove markes	from bending		\sim	/ . /	/				
	•	and dwg. H	old x-bolt with DT9701	per QSI002 and trim/ grind fl Use tube expander 1/2 x170 G to achieve dwg dimention.	ush per QS1002	Oc /2 B 13	/67/ 407/0	65				
160		QC5- Inspect part comp	leteness to step on W/O	0.00								
160 QC QC		Memo		0.00					0	OB 16	407/02	1
Quality Control												

	Johade	, Eta							
W/O:		~	WO	RK ORDER CHANG	ES				
DATE	STEP	- PR(OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _]
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NCR:			WORK ORDE	ORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	ion B Sign Date	& Verific	cation on C	Approval Chief Eng	Approval QC Inspector
			Criter Eng	Chief Eng	Date	3	· ·		
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Work Orde <i>May-29-12 2:56</i>		929		*849	729*						Page 4
Item ID: Revision ID:	D209-669-04	43		Accept	*N900	040	100) * s	Setup Sta	17	JS1*
•	Replacement 5 29/05/2012 16/07/2012	Skidtube Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	•	Cust Item I Customer:	ID:			Sto	P *N	IS2*
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:		ŀ	Run Sta Sto	1/	JR1*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
170 Skidtubes Skidtubes		Memo -Drill holes not to hit we	for wearplates using DT8 eb.Deburr	0.00 3217 Open holes to 19/64",	adjust stopper				_\$	9 0_	D.07
				open holes to .640	- 1						

190

QC5- Inspect part completeness to step on W/O

0.00 50712/05

190

Memo

0.00

Quality Control

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC inspector
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Work Ord May-29-12 2:5		929		*849	729*			-				Page 5
Item ID: Revision ID: Item Name:	D209-669-0			Accept	*N900	0040	100	n *	Setup	Start Stop	1 11	S1* S2*
Start Date: Required Date: Reference:	29/05/2012 : 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						ı V.	17
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*200 *200* HandFinish Hand Finishing		Pressure Wash per QS100	05 4.3	0.00						An	12	7-6
210		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00				45				M-L
210 Powder Coating	741	Memo START TIM OVEN TEM	PERATURE:	2 0.00 2 0 F				/ <u>X</u>	B			-12/07/0
W 131	4 11	FINISH TIM	10 -30									
*220 *220*		QC3- Inspect Part Finish		0.00				1,	L	d	MI	(1) = 7
QC		Memo		0.00				/	·	4	/ 4 /	1110+11

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Quality Control

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W/O:			WC	RK ORDER CHANGE	S							
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	R	esolution:	Dispositio	ı: <u>·</u>	QA: N/C Cld	osed:		Date: _				
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)						
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
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Work Orde May-29-12 2:56		929		*849	729*							Page 6
Item ID: Revision ID: Item Name:	D209-669-04			Accept	*N900	040	100)*	Setup S	Start Stop	*N	S1*
	29/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					^N	S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		Ĭ		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Tumber	Insp. Stamp
230 HandFinish Hand Finishing		insert holes in A/R Sikaflex exp 2-Coat D259 per Dwg D29 3-Inspect for 4-Install D28 with Sikaflex A/R Sikaflex exp	foreign object per QSI 02 355 Fwd & Aft Cap as pe c. Clean excess adhesive aflex-291 /\/\ \ \ \ \	0.00 wg. D2906. Use a drop of sets 5 & C um Jelly and install on D2 24 r Dwg D2906 and seal Fw	594-1 plugs as				<u> </u>		H	nloalo

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W/O:			WC	RK ORDER CHANG	ES	1.11			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA	\:	_ Date: _	
	Re	esolution:	Disposition	1: <u>'</u>	_ QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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Work Orde May-29-12 2:56	-	929		*849	729*					P	age 7
Item ID: Revision ID:	D209-669-04			Accept	*N900	<u>040</u> ′	100*	Setup		*NS1	*
Item Name:	Replacement S								Stop	*NS2	*
Start Date:	29/05/2012	Start Qty: 1.00	*1*		Cust Item 1	ID:					
Required Date: Reference:	16/07/2012	Req'd Qty: 1.00	*1*		Customer:						
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:		Run	Start	*NR1	*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NR2	*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Ac Code Qt			Reject Insp. Number Stam	
240		QC5- Inspect part comple	eteness to step on W/O	0.00			_		•		-1
* ? 4 n * QC Quality Control		Memo	Con Fred Steer and William	0.00	, ,						
Quanty Control		Foreign obje	Cap, Fwd Step and Wing W cts per QSI 024	valk of work to Current	Step Inspect for						
250				0.00					9		
250		Packaging						101	1/2	100	
Packaging		Memo		0.00			-			/	,
Packaging		Identify and Location:PPP Rev:	pack for shipping as per Pl	PPD209-669-043							
260		QC21- Final Inspection -	Work Order Release	0.00						112	\mathcal{M}
260								/	2/	7/18	X/
QC		Memo		0.00					<i>υ</i> , /	-t	7
Quality Control											_

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Dail Me	iospace	Llu							•					
W/O:			WC	RK ORDER CHANGE	S									
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Picklist Print

May-29-12 2:56:46 PM

Work Order ID: 84929

84929

D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

new IPP 08.02.13 LL, verified by: DD

			.05.10 + 01111	od by.LC								
Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	Manufactured	No	-			Each	81.0000		19	, /	400	
								**	OC 12	/67/69	<u> </u>	
			Location	B\$3263	Loc	<u>Oty</u>	Loc Code	1	19)			
			LG			5		_		•		
			1.0002	77727						-		
			LG002	78806				_				**
				79810		70						·
	Manufactured	No			110	Each	91.0000	1	1	•		
190*								**	SAC	2	Doa	5-21
			Location		Loc	Oty	Loc Code					
			HALL			91						
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	Manufactured	No		3000)	110		0.0000	_ 1	-(//	•		
								**	SUD.	.,	^_	391
						28-21	62 81	_	-T*)	<u>'0</u>	-0 /-0	J¥
1	Manufactured	No			230	Each	21.0000	2	2			
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			Location		Loc	<u>Qty</u>	Loc Code					
			FP002			21	Baile	i 57 —				
				65519		2	1000	. 9 ($\langle \gamma \rangle$			
				73347		16						
	Replacement	Replacement Item ID Mfg/Purch Manufactured Manufactured Manufactured Manufactured	Replacement Item ID Manufactured No Manufactured No Manufactured No Manufactured No Manufactured No	Replacement Item ID Manufactured Mo Manufactured Mo Manufactured Mo Manufactured Mo Manufactured Mo Location HALL Location FP002	Manufactured No Location Location Location Location Applies Location Location 77727 LG002 78806 79810 Manufactured No Location HALL 74777 8006 Manufactured No Location HOD Location FP002	Replacement Item ID Manufactured No Location Location No Location No Location No Location No No Location No No No No Location No No No No Location No No No Location No Location No Location No Location No Location No Location HALL 74777 8006 No No Location HALL 74777 8006 Location Location HALL 74777 8006 Location Location Location HALL 74777 8006 Location Location Location No Location Location FP002	Replacement Mfg/ Purch Item Primary Last Location Seq ID Measure	Replacement Mfg/ Purch Rem Primary Location Route Unit of Measure Manufactured No	Replacement Mfg/ Purch Item Location Location Route Location Req ID Measure Hand Manufactured No	Replacement Mfg/ Purch Item Docation Location Route Location Location Route Route Location Route Route Location Route Route	Replacement Mfg/ Purch Item Location Location Route Unit of Measure Hand Qty per Kit Qty Issued	Replacement Mfg/ Purch Item Primary Location Route Seq ID Measure Measure

		— - 							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
		solution:							
NCR:		\	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			Section B Verific			Approval	Approval
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May-29-12 2:56:46 PM

Work Order ID: 84929

Purchased

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

84929

D209-669-043

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

**

Required Qty: 1.00

AN3-5A

AN3-5A

			PO110111 N.W.
Location	Loc Oty	Loc Code	
ST350	1090		
115371	46		
117423	124		
110/0/			

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ST350		1090			
115371		46			
117423		124			
118626		31			
119355		200			
120187		500			1
121185		189			
	230	Fach	0.0000	4	4

Each

AN960JD10L

NAS1149D0332J Purchased

No

No

110151111

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12 12/07/0g

*AN960.ID101 * \times

Washer

ALS7-1032-130

Purchased

230

Each

2000

2,136.000

AI S7-1032-130 4 ALSU 1037-130 Insert

121444

Location Loc Qty Loc Code ST280 51 117717 27 118966 22 119775 2 ST282 2085 119530 73 120181 12

														
W/O:			WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector					
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May-29-12 2:56:47 PM

Page 3

Work Order ID: 84929

84929

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

D209-669-043

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

**

12/07/09

AN3C4A

BOLT

Location	Lo	c Qty	Loc Code		
ST350		1458	11122151	i	X 1 1
120187		57	•		
120521		28			
120769		38			
121205		1000			
121556		335			
	230	Fach	0.0000	44	44

AN960C10L

Purchased

No

11122063

*AN960C101 * x washer

D2594-3

Manufactured No 230

Each 2,418.000

Loc Code

D2594-3

O-Ring, 205 Skidtube

Location	Loc Qty
FP001	2418
65518	41
79496	984
79573	50
79755	1343

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W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _						
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)								
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FG

FP001

77056

80341

-41110	Johade												
W/O:			W	ORK ORDER CHANGES		٠.							
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Part No	•	PAR #:	Fault Cate	egory: i	NCR: Yes	No DQ	A:	Date: _					
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DATE	STEP	Description of NC	In late t		Section B Ve			Approval	Approval				
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Picklist Print Page 5 May-29-12 2:56:47 PM Work Order ID: 84929 *84929* Parent Item: D209-669-043 *D209-669-043* Parent Item Name: Replacement Skidtube **Required Date: 16/07/2012** Start Date: 29/05/2012 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured 230 Each 13.0000 St ** 12/04/09 Wearshoe Location Loc Qty Loc Code FG B85475 34806 FP001 11 77609 3 82254 8 D3566-1 Manufactured No 230 Each 31.0000 *D3566-1* ** Gasket Location Loc Qty Loc Code FP -22 1384879 81619 10 FP002 53 68924 2 80919 3 83898 16 D3566-5 Manufactured 230 Each 21.0000 *D3566-5* 12/07/05 ** Gasket Location Loc Qty Loc Code FP 12 12 82275 FP002 9

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W/O:			WO	RK ORDER CHANGI	ES	. ,		-	**************************************
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Part No: PAR #:									
			Disposition	QA: N/C CI	osed:		Date: _		
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		Description of NC		on B	Verific	cation	Approval	Approval	
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Description	SKIDTUBE ASSEMBLY	SKIDTUBE ASSEMBLY		EXIRUSION	CROSS BOLT SPACER	I PLUG	O-RING	AFT CAP	WEB	WEB	WEARSHOE (REPLACES D2577-1)	WEARSHOE (REPLACES D2577-3)	WEARSHOE (REPLACES D2577-5)	WEARSHOE	GASKET	GASKET	GASKET		INSERT			BOLT	BOLT	WASHER	WASHER
Part Number	D2906-041	D2906-043	70000	D2500-1-190	D2579	D2594-1	D2594-3	D2855	D2926-1	D2926-3	D3564-9	D3564-11	D3564-5	D3564-15	D3566-1	D3566-5	D3566-15		ALS7-1032-130	or AKS7-1032-130	or AKS4-1032-130	AN3C4A	AN3-5A	AN960C10L	AN960JD10L
QTY -043		×	,	-	19	14	14	2		1	1	1	-		2	1			44			4	4	4	4
QTY -041	X		,		22	12	12	2	1		1	1	1	1	2	1	1		20			20	4	20	4

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SUBJECT TO AMENDMENT

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- S)
- 2) LENGTH OF D2806-1 EXTRUSION BEFORE BENDING = 190 INCHES.
 3) INSERT D2926-1/3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291
 ADHESINE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
 ADEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200
 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200
 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200
 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 6) USE DART DRILL TEMPLATE DT2906-041) OR DT2906-0431 (D2906-043)
 TO LOCATE AND DRILL &0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3CAA BOLTS AND AN960C10L
 WASHERS WITH SIKAFLEX-241/291.
 7) WELDING TO BE DONE PER DART QSI 004.
 8) FINISH:
 8) FINISH:
 8 ACID ETCH, ALOPINISH. 6

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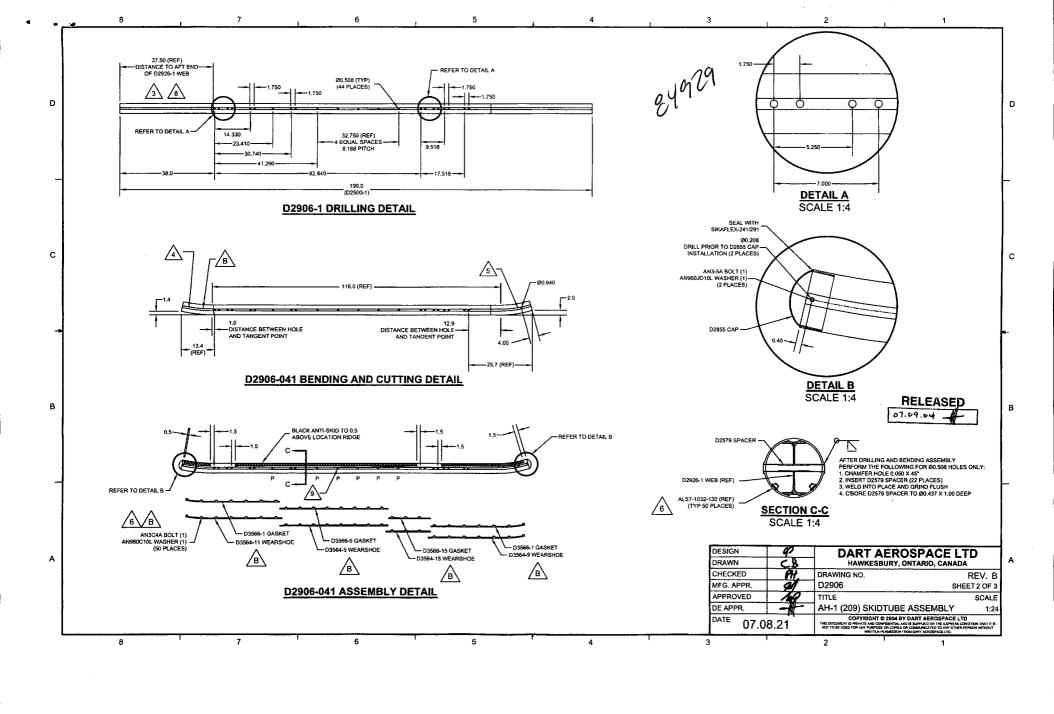
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

RELEASED 07.04.04

LTD IS CONDITION THAT IT IS	EROSPACE ED ON THE EXPRES	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION HAT IT IS	07 08 21	0.70	DATE
NTS	EMBLY	AH-1 (209) SKIDTUBE ASSEMBLY	1	۳.	DE APPR.
SCALE		TITLE	149	VED	APPROVED
SHEET 1 OF 3	S	D2906	GM	PPR.	MFG. APPR.
REV. B		DRAWING NO.	OH.	ED	CHECKED
i e	IO, CANA	HAWKESBURY, ONTARIO, CANADA	CB		DRAWN
LTD	ACE	DART AEROSPACE LTD	.		DESIGN
DATE	ВУ	DESCRIPTION	O W		REV.
04.06.22	g		SSUE	NEW ISSUE	٧
		PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	:3: CORRECTE!)7: 38 PLACES \	PG3C PG3C	
		PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;	7: REMOVE AF	PG 2 C	ı
07.08.21	8		PG 1: ADD NOTE 10;	PG 1:	മ
		CHANGE WEARPLATE HARDWARE TO SS;	SE WEARPLAT	CHAN	_
		ADD STAINLESS STEEL WEARPLATES AND GASKETS	TAINLESS STE	ADDS	
		UPDATE DRAWING FORMAT: RE-ORGANIZE:	TE DRAWING F	- NDDA	

W/O:			WC	ORK ORDER CHANG	GES			,				
DATE	STEP	PRO	Ву	,	Date Q	ty Approval Chief Eng / Prod Mgr	Chief Eng /					
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQA: _	Date: _	<u> </u>			
		esolution:										
NCR:		\	WORK ORDI	ER NON-CONFORM	ANCE (N	CR)						
DATE	CTED	Description of NC	Corrective Action Section B				Verification	on Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Section C		QC Inspector			
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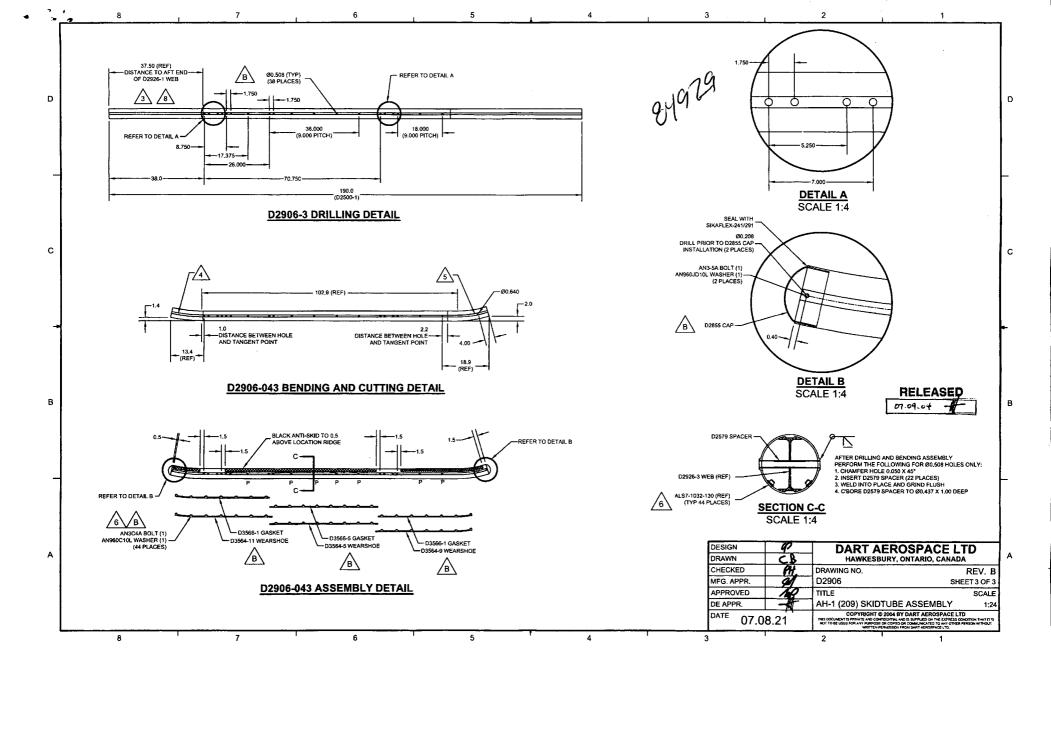
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W/O:			V	VORK ORDER CHANG	SES			•	
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			Office Eng	Officer Eng	Date				
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Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** DATE STEP **PROCEDURE CHANGE** By Date Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: Date: Resolution: _____ Disposition: _____ QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Approval Chief Eng Approval QC Inspector **Description of NC STEP** DATE Sign & Initial **Action Description** Section A Date Chief Eng Chief Eng